

Date: Monday, 11/20/2006 7:57:15 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 29241	
Estimate Number : 11403	
P.O. Number : N/A	Part Number : D3296041
This Issue : 11/20/2006 S.O. No. : N/A	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 10/30/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 11/22/2006 Qty: <i>8</i> Um: Each
Checked & Approved By : <i>[Signature]</i> 06-11-20	
Comment : Est. C 05.10.14 Added step 14 KJ/EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	B 29243

SB 06/11/20

8

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door Panel		B 29244

SB 06/11/20

8

3.0	D31617	Hinge 14"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 14"

Batch: B 29245

SB 06/11/20

8

4.0	D31619	Hinge 17"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 17"

Batch: B 29246

SB 06/11/20

8

X

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 29241

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 150.0000 Each(s)
 Rivet, Universal Head
 Batch: M 102328

ml 06/11/24

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Fabricate & assemble as per Dwg D3296.

ml 06/11/24

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 06/11/27 (8)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06/11/30 (8)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06/12/01

10.0 D2137 Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Decal - No Step
 Pick:

Qty Part Number Description Batch
 1 D2137 Decal B 23661 (X1)

B 24358 x7

ml

11.0 D2419 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Handle
 Pick:

Qty Part Number Description Batch
 1 D2419 Handle B 24374 (X2)

B 28282 x2

ml

Step 6

Tried to ~~say~~ in the ordi

Scrap one hinge ~~D 3166~~ D 3161-9.





But made to assy.

and oct 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/11/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/27	6	When installing A3296-1 and A3296-3 on hinge they were not aligning properly (2 door ass'y scrap)		remove rivets and hinge and replace 17" B29246 - hinge Qty 3	 06/11/27	AA 06/11/27	 06/11/27	AA 06/11/27
				- rivet M102328 Qty 36 MS20470AD44	 06/11/27	AA 06/11/27		AA 06/11/27

NOTE: Date & initial all entries

Date: Monday, 11/20/2006 7:57:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 29241

Part Number: D3296041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D24620040	Seal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Seal

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2462-0040	Seal	
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B29456

(x8)

ml

13.0	D24620053	Seal
------	-----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Seal

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2462-0053	Seal	
---	------------	------	--

B29456

(x8)

ml

14.0	D24620245	Seal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Seal

Pick:

Qty	Part Number	Description	Batch
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1	D2462-0245	Seal	
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B29456

(x8)

ml

15.0	D27281	Dart Logo label small
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Dart Logo label small

Pick:

Qty	Part Number	Description	Batch
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1	D2728-1	Decal	
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B24215

(x8)

ml

16.0	AN960JD6	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	AN960JD6	Washer	
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m6085

(x8)

ml

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 29241

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation: Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD46 Rivet

M 18615

ml

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

ml 06/12/01

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/01 (8)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 1.5*

06/12/05 (8)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/05 (8)

Job Completion



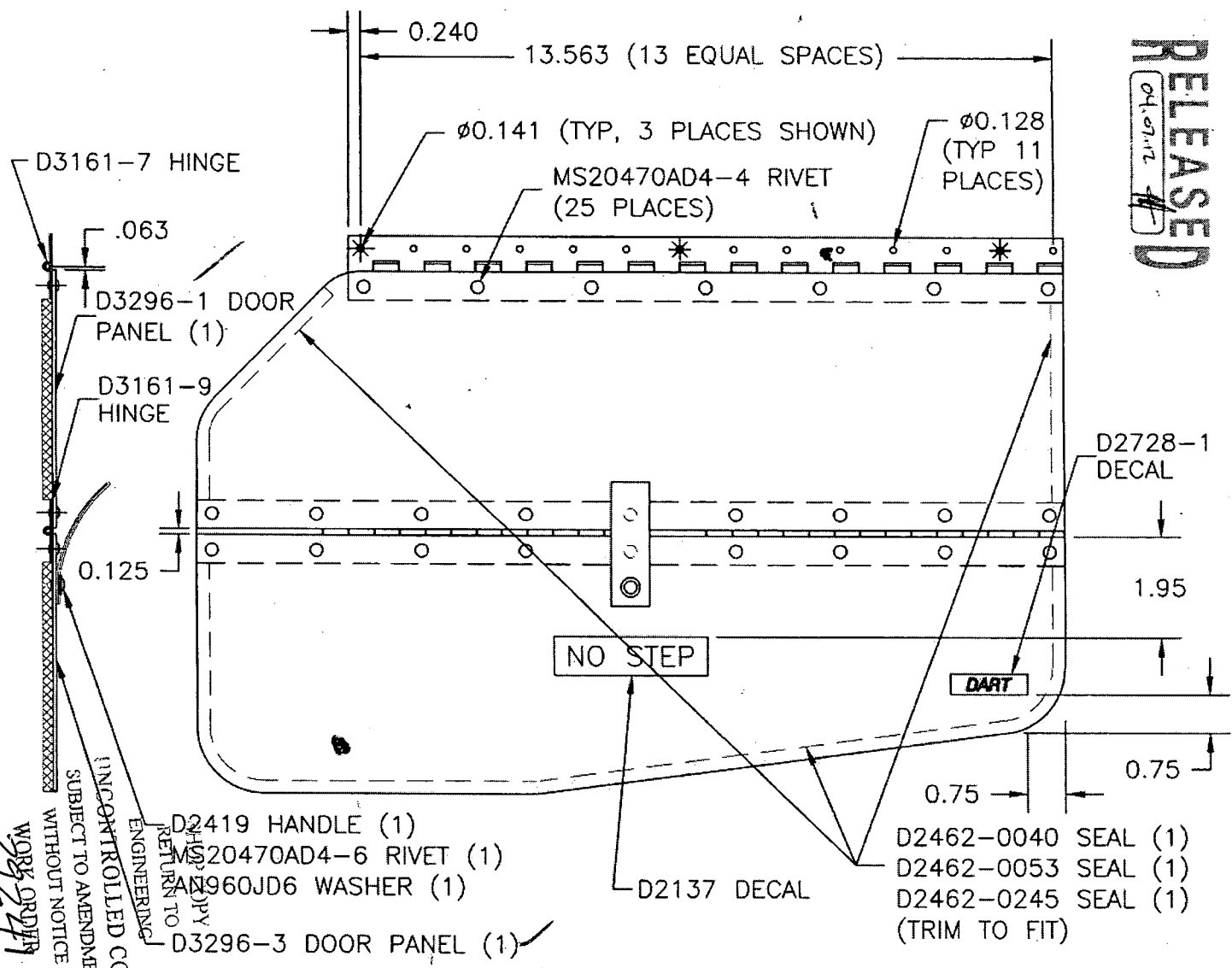
06/12/05

DART



RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3296	1 OF 2
04.06.28		TITLE	SCALE
A	04.06.28	DOOR ASSEMBLY	1:3
		NEW ISSUE	



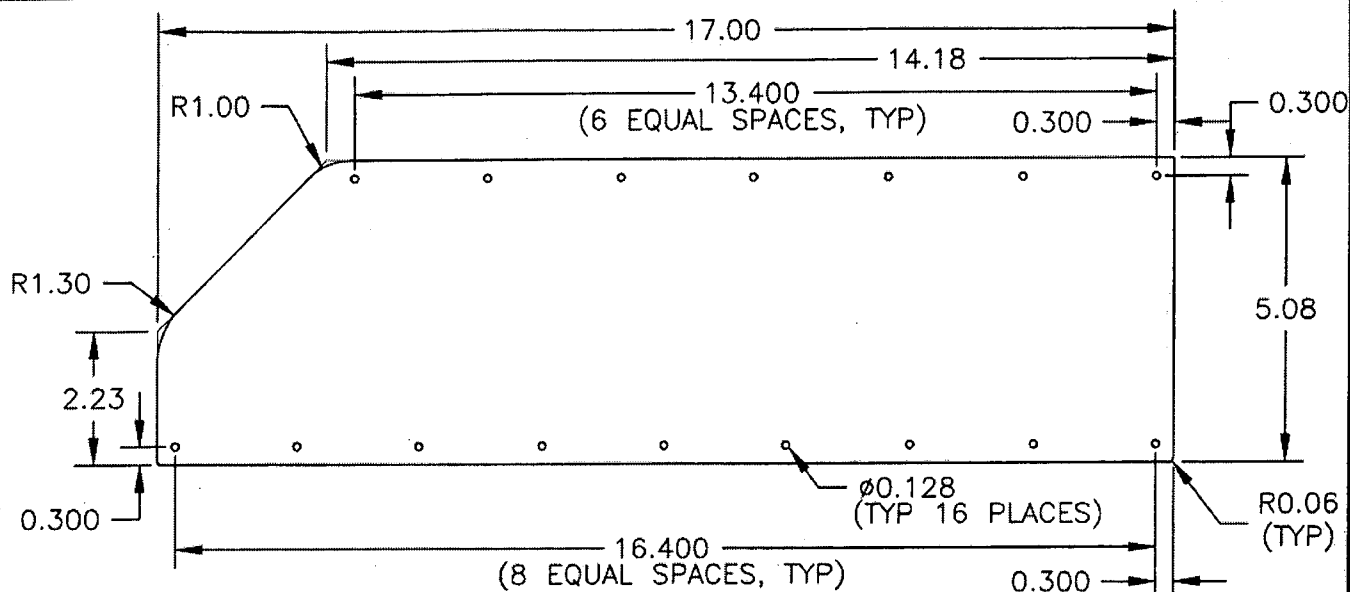
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

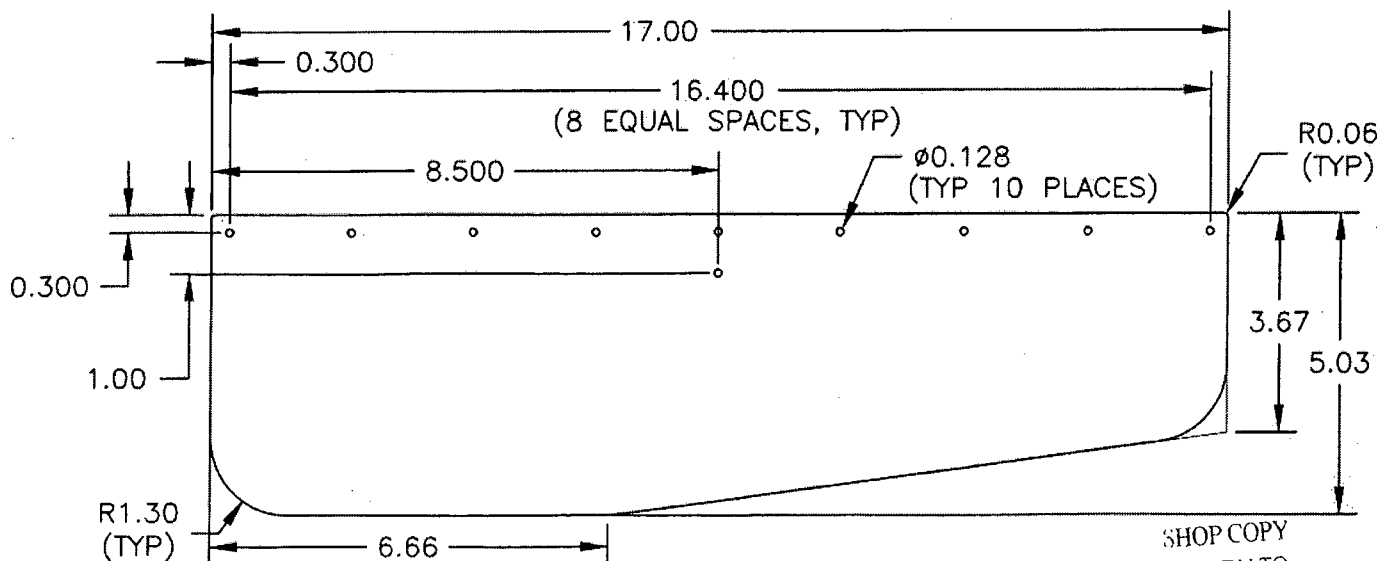
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WITHOUT NOTICE
WORK ORDER
29247



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
DART AEROSPACE LTD
64-87-12
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WORK ORDER
NO. 29241

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